

Work Order ID 48619

July 6, 2009 2:20:10 PM



Page 1

Item ID: D119-675-012

Accept



Setup Start



Revision ID: N/A

Stop



Item Name: Heli-Access-Step RH

Start Date: 07/06/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00



Customer:

Reference: RETURN 09-Old

Approvals: Process Plan: MTF

Date: 6/1/09 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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N/A	Rev N/A
-----	---------

100	0.00
-----	------



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP 119-675-012 CHG003



110



Pick Kit

0.00



Packaging

Memo

0.00

Packaging

120



QC4- 100% Inspect kits for completeness

0.00

QC

Quality Control

Memo

0.00

→ Sort lot # ④ RX

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Page 2

Item ID: D119-675-012

Accept



Setup Start



Revision ID: N/A

Stop



Item Name: Heli-Access-Step RH

Start Date: 07/06/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

0.00

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D119-675-012

Location: _____

Nec 10/02/11

140



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/02/11 JG

W 09.07.09

Date: Wednesday, 17/06/2009 9:32:44 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.		Drawing Name	: D119-675-012 STEP		
Job Number	: 48619					
Estimate Number	: 10804					
P.O. Number	:		Part Number	: D119675012		
This Issue	: 17/06/2009	S.O. No. :	Drawing Number	: R09-066		
Prsht Rev.	: NC		Project Number	:		
First Issue	: / /	Type : LARGE FAB ASSY	Drawing Revision	:		
Previous Run	: 00015		Material	:		
Written By	: <i>Z 0906-7</i>		Due Date	: 24/06/2009 Qty: 1 Um: Each		
Checked & Approved By	: <i>MF 09-06-17</i>					
Comment	:					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D119675012	Heli-Access-Step RH	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Heli-Access-Step RH Original B46572 @ CHG003	
2.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP Step and lugs are in good condition, and only need to be cleaned and touched up. New hardware & paper work required.	 <i>for CL 09/07/07</i>
3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1 Clean the D3043-042 step; and the D3041-1 lug clamps, and touch-up with Imron white, as neatly as possible.	 <i>BR 09-07-2</i>
4.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	 <i>S 09/07/02</i>
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Pick the following items.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 17/06/2009 9:32:44 AM
User: Melanie Fauteux

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D119-675-012 STEP

Job Number: 48619

Part Number: D119675012

Job Number:



Seq. #:

Machine Or Operation:

Description :

Ensure the following are included in the kit, and are clean and complete:

- S 1x D3043-042 step
S 4 x D3041-1 clamp - B42946
S 2x D3041-3 clamp 46615 40494
4x D3042-1 clamp

****See attached original w/o for the original batch numbers****

C 209107/07.

New labels, and decals with the new batch # @ CHG003 are required along with new paperwork. S 2112/07

6.0 D2182B032 Rubber Cushion



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
4 D2182B032 Rubber Cushion B39986

atg/2

sk

7.0 D2274 Radius Block



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
8 D2274 Radius Block 471796

9/7/2

SP

8.0 D26173 Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
4 D2617-3 Bushing 48613

9/7/2

SB

9.0 D26175 Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
8 D2617-5 Bushing 568168

9/7/2

SV

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 17/06/2009 9:32:44 AM
User: Melanie Fauteux

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D119-675-012 STEP

Job Number: 48619

Part Number: D119675012

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D2732

Rubber Extrusion

4A11



Comment: Qty.: 1.0660 f(s)/Unit Total : 1.0660 f(s)

Qty Part #

Description

Batch

4 D2732-032

Rubber cushion

B4318

9/1/2

SP

11.0

AN412A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

8 AN4-12A Bolt

M111605

9/1/2

SB

12.0

AN411A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

4 AN4-11A Bolt

M106605

9/1/2

SE

13.0

AN415A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

4 AN4-15A Bolt

M110399

9/1/2

SI

14.0

AN960JD416

Washer



Q

Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

12 AN960JD416 Washer

M111279

9/1/2

SO

Date: Wednesday, 17/06/2009 9:32:44 AM
User: Melanie Fauteux

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D119-675-012 STEP

Job Number: 48619

Part Number: D119675012

Job Number:



Seq. #: Machine Or Operation:

Description :

15.0 MS21042L4 Nut



(14)

Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4 Nut (or -4) M110501

1 paperwork package from Step 1

9/7/2

SF

16.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

LUG
****Ensure the parts form 5.0 are included, and are identified with the original batch #'s per the original w/o attached****

Sugloz/1 (14)

17.0 ✓ PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D119-675-012

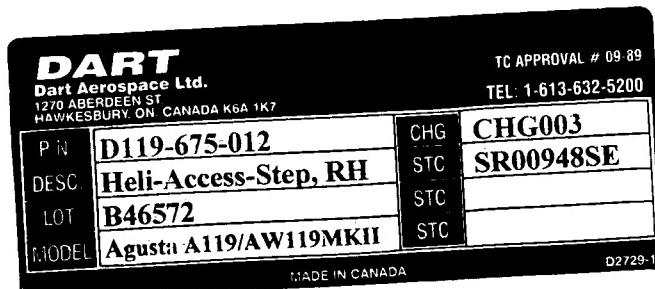
Location: _____

18.0 ✓ QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Date: Thursday, 19/03/2009 11:01:57 AM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: A119 STEP INSTALLATION R/H		
Job Number	: 46572			Part Number	: D119675012		
Estimate Number	: 10132			Drawing Number	: N/A		
P.O. Number	:			Project Number	: N/A		
This Issue	: 19/03/2009	S.O. No. :		Drawing Revision	: N/A		
Prsh Rev.	: NC			Material	:		
First Issue	: / /	Type	LARGE FAB ASSY	Due Date	: 10/04/2009		
Previous Run	: 42917			Qty:	4 Um: Each		
Written By	:						
Checked & Approved By	: JUL 09 03.19						
Comment	: Est Rev:D Removed Manufacturing JLM 05-11-01						
	Est Rev:E change to rev.b as per ECN1107 DD verified by:						

REFERENCE ONLY

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL for JUD 09/04/01
	Comment: DOCUMENT CONTROL	Photocopy bluefile & type labels per PPP 119-675-012 CHG003
2.0	46572A	A119 STEP WELDMENT RH
	Comment: Sub-Component A119 STEP WELDMENT RH 1 x D3043-042 Batch	46572A SO
3.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1	
	Pick: Packing Kit	
4.0	D2182B032	Rubber Cushion
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)	<u>re-package in IP</u>
	Pick: Packing Kit	
	Qty Part Number Description Batch	
	4 D2182B032 Rubber Cushion	139984
		<u>measured S 9/3/31</u>
5.0	D2274	Radius Block
		New
	Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)	
	Pick: Packing Kit	
	Qty Part Number Description Batch	
	8 D2274 Radius Block	16 BY2099 BY4547 9/3/31 5L

Date: Thursday, 19/03/2009 11:01:57 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: A119 STEP INSTALLATION R/H

Job Number: 46572

Part Number: D119675012

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 D26173 Bushing



New



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

4 D2617-3 Bushing B44360

7.0 D26175 Spacer



New



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

8 D2617-5 Bushing B45663 ⑧ 24 46607

8.0 D2732 Rubber Extrusion



re-package



Comment: Qty.: 1.0660 f(s)/Unit Total : 4.2640 f(s)

Qty Part # Description Batch

4 D2732-032 Rubber cushion 38509

memorandum 5/23/09

New

SF

9.0 D30411 Clamp



re-package



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

4 D3041-1 Clamp 42946

: clear touch-up

SF

10.0 D30413 Clamp



re-package



(4x)

Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

2 D3041-3 Clamp 40494 ③

1809/04/09 (4x)
B46615 X5 9/3/09

SF

Date: Thursday, 19/03/2009 11:01:57 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: A119 STEP INSTALLATION R/H

Job Number: 46572

Part Number: D119675012

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 D30421 Clamp



Re package

Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch
4 D3042-1 Clamp B34047S

12.0 AN412A Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch
8 AN4-12A Bolt M110704

10 New

M109754

SP

13.0 AN411A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch
4 AN4-11A Bolt M106605

New

SP

14.0 AN415A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch
4 AN4-15A Bolt M110399

New

SP

15.0 AN960JD416 Washer



26

M110363

SP

Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch
12 AN960JD416 Washer M108161

New

9/3/31

SP

Date: Thursday, 19/03/2009 11:01:57 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: A119 STEP INSTALLATION R/H

Job Number: 46572

Part Number: D119675012

Job Number:



Seq. #: Machine Or Operation:

Description :

16.0 MS21042L4

Nut



(X)

Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

{ 12 }

? New

36

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4 Nut (or -4)

1 paperwork package from Step 1

M107499

M107282

9/3/31

SP

17.0 QC4

INSPECT 100% KITS FOR COMPLETENESS



Sokolos

4R4

(X)

Comment: INSPECT 100% KITS FOR COMPLETENESS

18.0 PACKAGING 1

PACKAGING RESOURCE #1



(X)

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D119-675-012

Location: 82 Rev C

9/4/9

SP

19.0 QC21

FINAL INSPECTION/W/O RELEASE



09/04/11/10

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



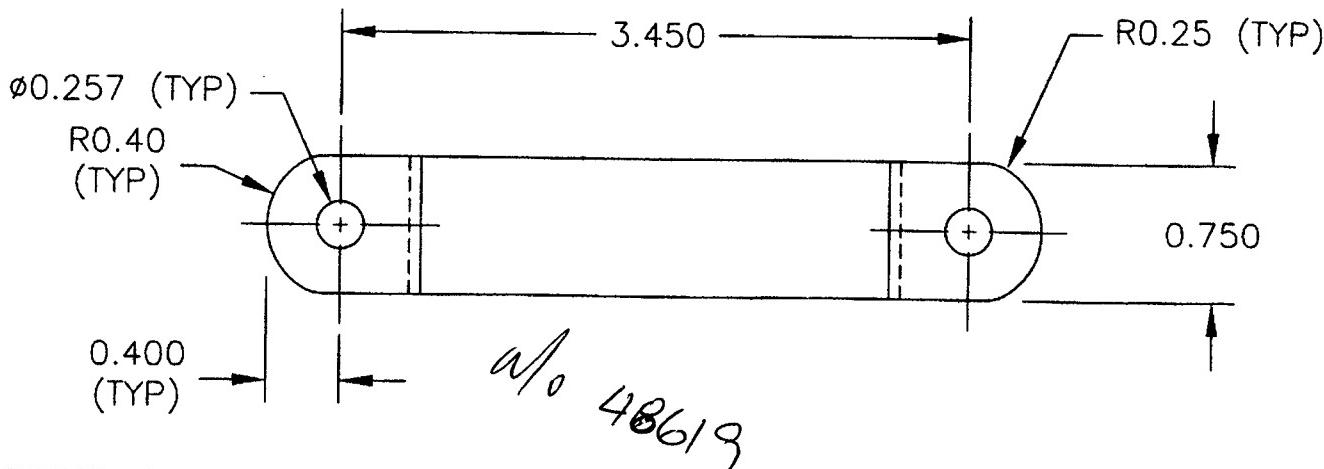
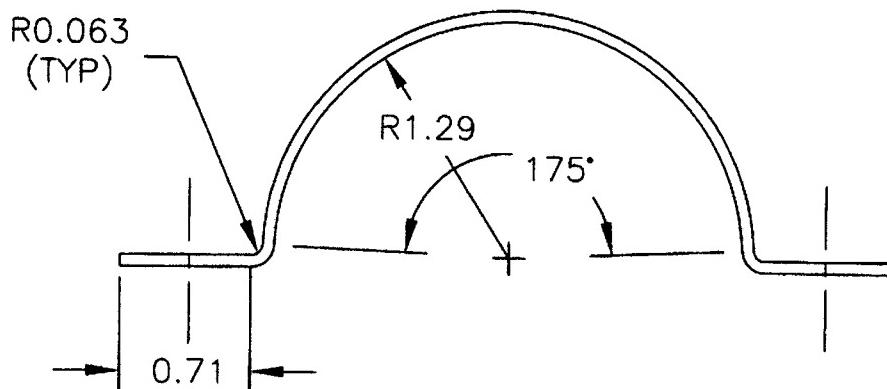
MF
09-04-09

DART



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
CHECKED <i>CP</i>	APPROVED <i>CP</i>	DRAWING NO.	D3042	REV. A
DATE 01.06.29		TITLE	CLAMP	SCALE 1:1
A	01.06.29	NEW ISSUE		

RELEASED
01.07.09



D3042-1

- 1) MATERIAL: AISI 304/316 SS ANNEALED PER AMS 5513/5524
0.063 THICK
- 2) FLAT LENGTH: 5.713 END-TO-END
4.913 HOLE-TO-HOLE
- 3) BREAK ALL SHARP EDGES 0.005-0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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Bill Beckett

From: David Shepherd [dshepherd@dartaero.com]
Sent: June 2, 2009 1:16 AM
To: 'Bill Beckett'
Subject: RE: D119-675-012

Bill,

I got called late on Friday before I left for Kelowna and had to make a quick decision to send this off to Skyline "no charge" at the request of Agusta.

Grant has no interest in the step. I already tried that while I was there. The step was installed on the aircraft for maybe 5 flights where I was aware of exactly what was happening to the step.

(Still in Dart control???)

It is tertiary structure and doesn't see very high loads in flight.
We could probably equate this to doing a trial fit in the shop.

In this case, I think that we can receive the step in, inspect it, touch up as necessary, and re-sell as new.

The hardware and rubber cushions should be replaced.
We should give it a new b/n and new labels.

David



-----Original Message-----

From: Bill Beckett [mailto:bbeckett@dartaero.com]
Sent: Monday, June 01, 2009 7:08 AM
To: 'David Shepherd'
Subject: D119-675-012

David,

This step was sent "no-charge" to Skyline for testing with the basket, crosstubes etc. for vibration analysis.

Is this step still saleable as new? Or is it now "serviceable"? If serviceable, any suggestions how to dispose of it? Would Grant buy it?

Thanks,

Bill

No virus found in this incoming message.

Checked by AVG - www.avg.com

Version: 8.5.339 / Virus Database: 270.12.48/2147 - Release Date: 05/31/09 20:45:00